

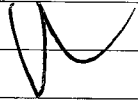
Work Order ID 118379

118379

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Item ID: D205-523-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Rappel 300 Lbs
 Start Date: 7/21/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/21/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

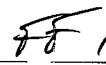
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9301	Rev A								

100
100 DOCUMENT CONTROL 0.00
 DC
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy blue file & type labels as per PPP D205-523-011, CHG 002

DAS
06
9-89

JUL 21 2014

105
105 0.00
 Small Fab
 Memo 0.00
 Small Fab PULL FROM STK:
 1 X D205-523-011 B9865
 PULL D1005 FROM KIT (B9728)
 RE-ASSEMBLE PER DRWG

1  14-07-21

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Item ID: D205-523-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Rappel 300 Lbs

Stop ***NS2***

Start Date: 7/21/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							
115									
QC	Memo	0.00							
Quality Control									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control	REINSPECT KIT								
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	REPACKAGE USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								

EB
14/07/21

JUL 21 2014

DAS
08
9-89

①

8

JUL 21 2014

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Item ID: D205-523-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Rappel 300 Lbs

Stop ***NS2***

Start Date: 7/21/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/21/14 Req'd Qty: 1.00

1

Customer:

Reference: rework

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-07-21

MF
14-7-21

Picklist Print

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Work Order ID: 118379

118379

Parent Item: D205-523-011

D205-523-011

Parent Item Name: Heli-Rappel 300 Lbs

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C99.08.19Re-formatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

33116		Purchased	No				Each	5.0000		2			
33116									**			FF 14-07-21	
STUD FITTING													

Location	Loc Qty	Loc Code
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ST389	1	
M125861	1	
ST397	4	
M129357	4	
		2

D205-523-011

Manufactured No

D205-523-011

Heli-Rappel 300 Lbs

MS21042L6 06

Purchased No

9-89

MS21042L6

Nut

Location	Loc Qty	Loc Code
----------	---------	----------

ST307	323	
m127831	23	
m128635	3	
m129499	297	
		2
		2

NAS1149D0616J

Purchased No

NAS1149D0616J

WASHER

Location	Loc Qty	Loc Code
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ST276	408	
122815	408	
		2

**

FF 14-07-14

[illegible]

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D205-523	REV. SHEET 1 OF 1
DATE 98.09.29		TITLE PERSONNEL RAPPEL INSTALLATION	
C	96.04.09	MODIFICATION OF AN BOLTS	
D	96.06.14	ADD WEIGHT + BALANCE	
E	98.09.29	INCLUDED DSI 9064, MODIFIED BOLTS	

PARTS LIST:

-011	-012	Part No.	Description
X		D205-523-011	205/212/412/214 PERS. RAPPEL INSTL. KIT, LH
	X	D205-523-012	205/212/412/214 PERS. RAPPEL INSTL. KIT, RH
1	1	D1005	SLIDE BAR ASSEMBLY
1	1	D2224	RAPPEL ANCHOR
2	2	D2229	DOUBLER
		S-13A	<i>elic Downing Sylvie whitnes</i>
4	4	AN5-14A	BOLT
8	8	AN960JD516	WASHER
4	4	MS21042-5	NUT (OR MS21042L5)

GENERAL NOTES

1. WHEN MAKING HOLES IN ROOF HONEYCOMB PANEL TO MOUNT D2224 ANCHOR, PROCEED AS FOLLOWS:
 - a) DRILL 3/8" (0.375 DIA) HOLES THROUGH PANEL AT LOCATIONS SHOWN ON SHEET 3.
 - b) CLEAN OUT HONEYCOMB 1/4" AROUND HOLE BETWEEN UPPER AND LOWER SKINS.
 - c) APPLY TAPE TO UNDERSIDE OF SKIN (TO STOP EPOXY FILLER GOING THROUGH).
 - d) FILL CAVITY BETWEEN SKINS COMPLETELY WITH 'METALSET A4' OR SIMILAR EPOXY POTTING COMPOUND.
 - e) AFTER THE EPOXY HAS COMPLETELY CURED, DRILL 5/16" DIA FINISH HOLE SIZE FOR AN5 BOLT.
 - f) CLEAN UPPER AND LOWER SKIN FACES AND BOND D2229 DOUBLERS IN PLACE WITH 'METALSET A4' OR SIMILAR EPOXY ADHESIVE. ALLOW TO CURE COMPLETELY BEFORE INSTALLING D2224 ANCHOR AND BEFORE TORQUING THE AN5 BOLTS.